

Work Order ID 48495

June 26, 2009 12:45:22 PM



Page 1

Item ID: D3766-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Rear Rail

Start Date: 15/07/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: *mp*

Date: *05-07-09*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3766

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-cut tube to length as per dwg D3766 1/2-drill holes thru to finish size as per dwg D3766 using DT9413, Drill holes labelled #3, #3- deburr

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

120

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

Cancel

Work Order ID 48495

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Page 2

Item ID: D3766-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Rear Rail

Start Date: 15/07/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Picklist Print

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Page 1

Work Order ID: 48495

Parent Item: D3766-3RevB

Parent Item Name: Rear Rail



Start Date: 15/07/2009

Required Date: 03/08/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.000W.188		Purchased	No			100	f	0.0000	29.3968			
												
6061T6 RD TUBE 1.00 X .188W												

Date: Thursday, 11/06/2009 11:55:50 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : REAR RAIL
Job Number : 48495	
Estimate Number : 13494	
P.O. Number :	Part Number : D37663
This Issue : 11/06/2009 S.O. No. :	Drawing Number : D3766 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 42873	Material :
Written By :	Due Date : 19/06/2009 Qty: 10 Um: Each
Checked & Approved By : <u>Julie Dawson</u>	
Comment : Est Rev:A 08-07-21 revB as per dwg DD verified by:EC Est Rev:B Added Drilling Tooling 08-08-27 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M6061T6T1000W188	6061T6 RD TUBE 1.00 X .188W
-----	------------------	-----------------------------



Comment: Qty.: 2.9323 f(s)/Unit Total: 29.3234 f(s)
 6061T6 RD TUBE 1.00 X .188W
 batch: _____

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3766

2-drill holes thru to finish size as per dwg D3766 using DT9413 ,Drill holes labelled #3.

3- deburr

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/06/2009 11:55:50 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR RAIL

Job Number: 48495

Part Number: D37663

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



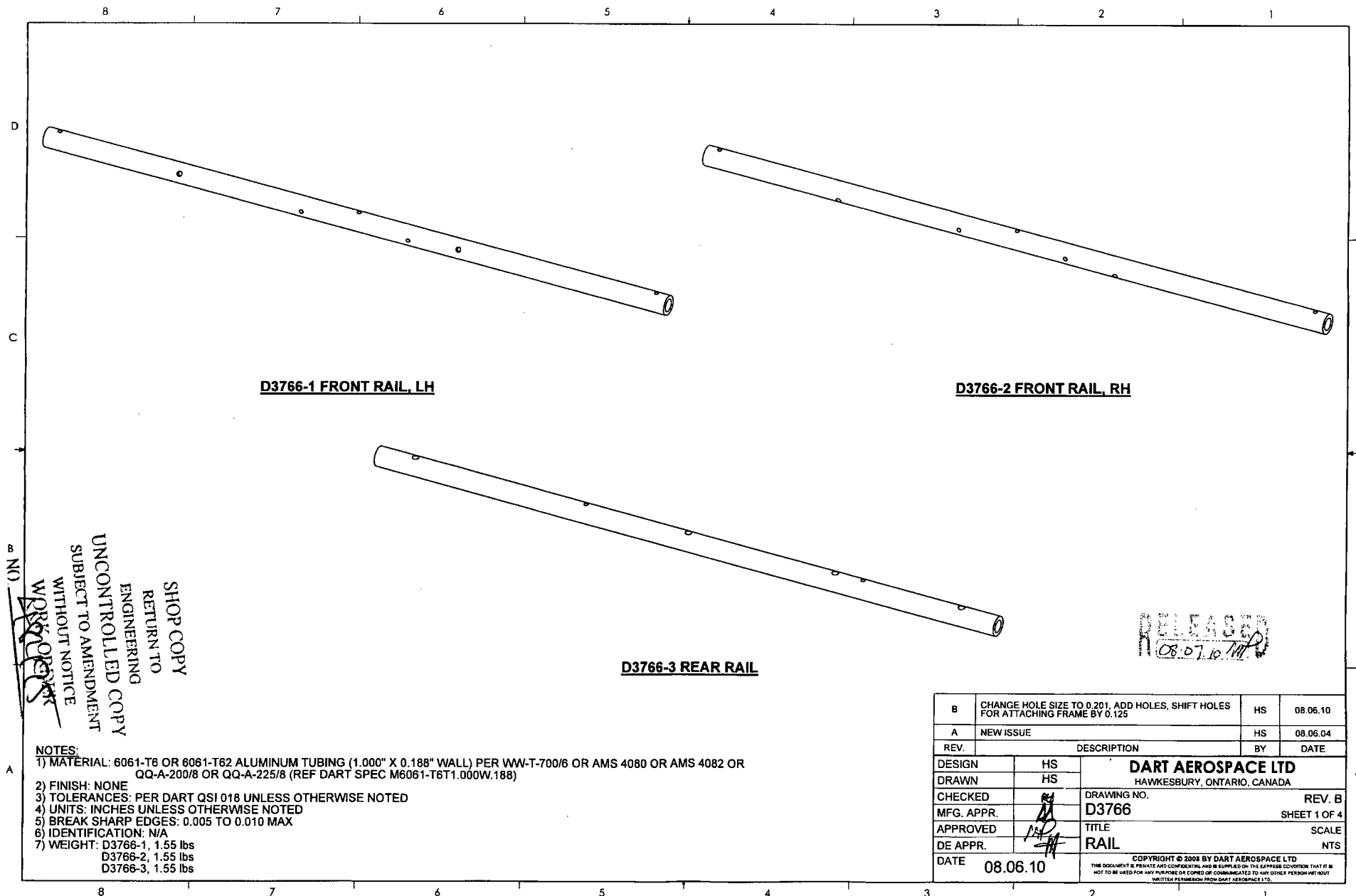
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

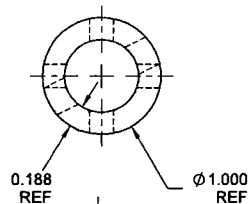
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

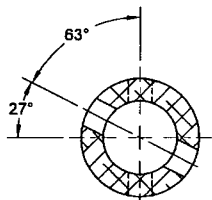


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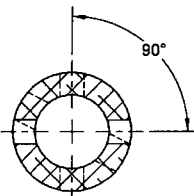
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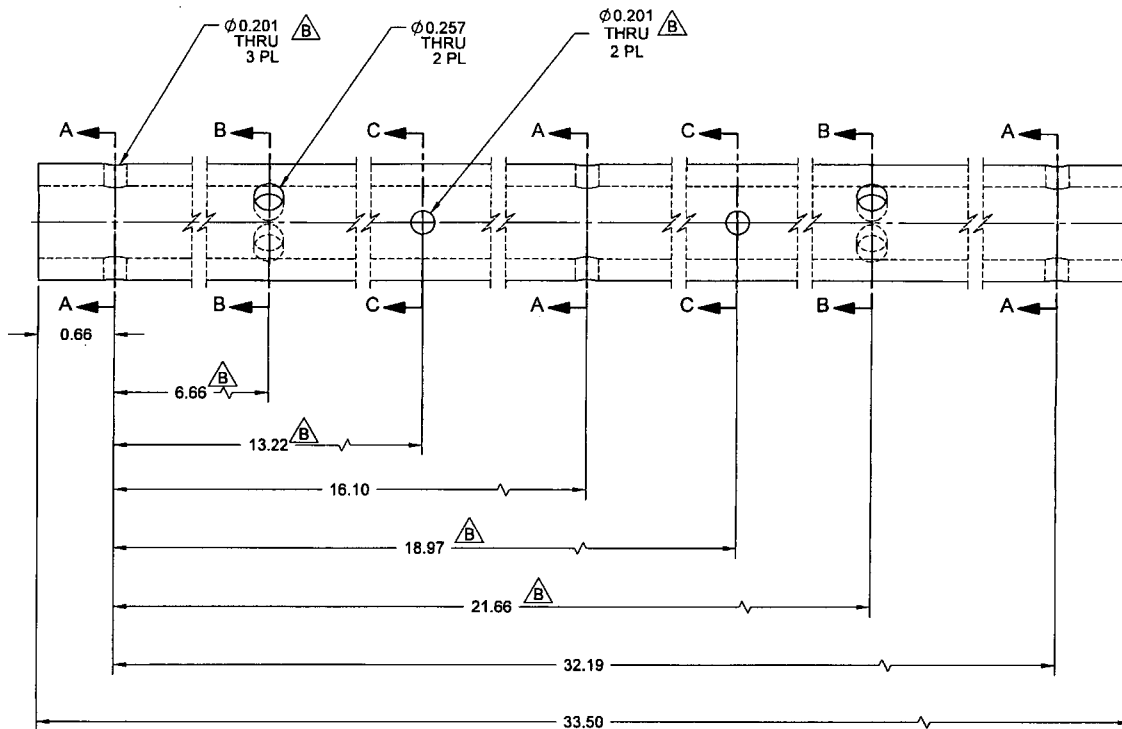
SECTION A-A



SECTION B-B





SECTION C-C



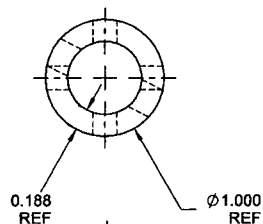
D3766-1 FRONT RAIL, LH

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08-07-10

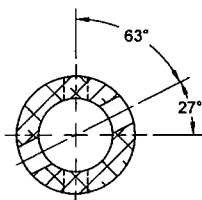
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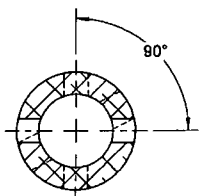
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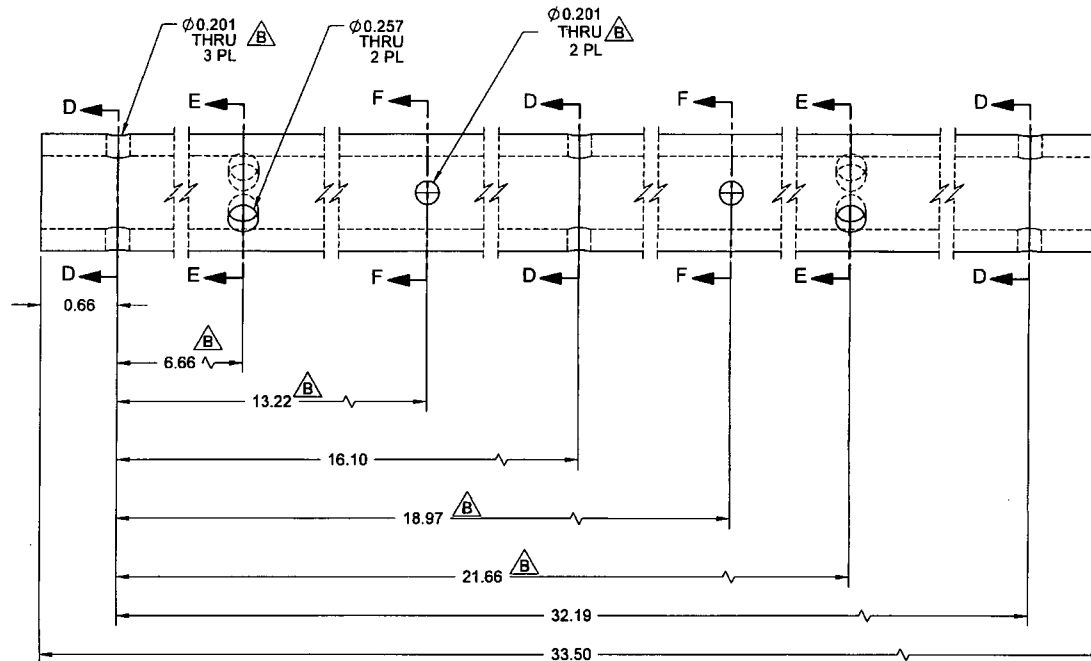
SECTION D-D



SECTION E-E






SECTION F-F



D3766-2 FRONT RAIL, RH

RELEASED
08-07-10 NPO

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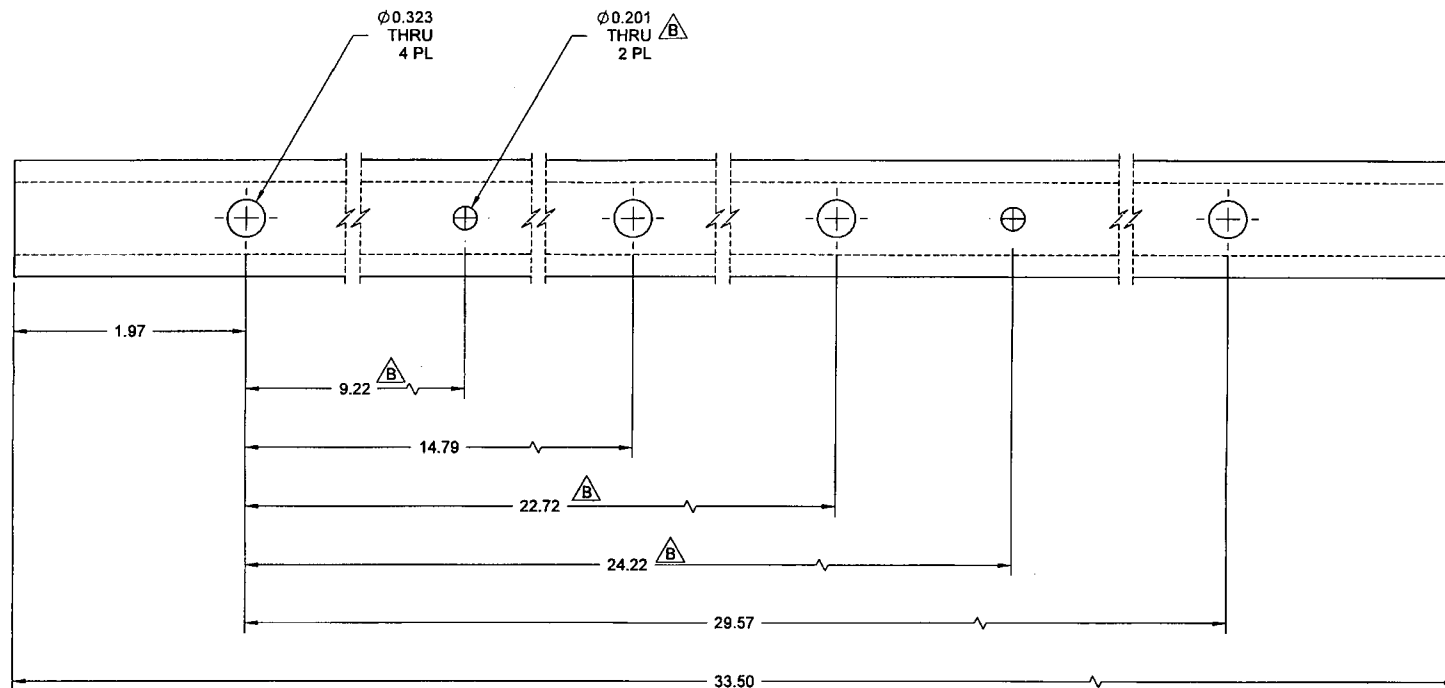
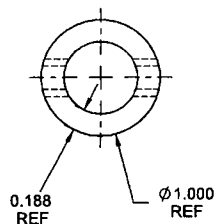
A

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D3766-3 REAR RAIL

RELEASED
08-07-10

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